

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024321**Date Inspected:** 07-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite

CWI Name:	John Pagliero		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A
Component:	SAS OBG	

Bridge No: 34-0006**Summary of Items Observed:**

Quality Assurance inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 8E PP64 E3 Lifting Lug Holes VT, MT and UT
2. 10W 11W C1 Diagonal Plate Splice (Inside)
3. 8W PP64 Lifting Lug Holes VT, MT and UT
4. 8E PP64 E3 Lifting Lug Holes VT, MT and UT
5. 9E PP77 E3 Lifting Lug Holes #1 & 3
6. 9W PP76 W4 #1
7. 2W PP18 A1 Storm Ties (Temporary Catwalk)

1. 8E PP64 E3 Lifting Lug Holes VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on Lifting Lug Holes (LLH) at 8E PP64 E3. The QA Inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing utilizing a G.E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

2. 10W 11W C1 Diagonal Plate Splice (Inside)

The QA Inspector randomly observed ABF welding operators Song Tao Huang and Jin Quan Huang performing Flux Core Arc Welding w/gas (FCAW-G) operations in the 3G vertical position on face C1 inside of the OBG. The QA Inspector observed the QC Inspector John Pagliero as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1. The work progressed throughout the QA Inspector's shift. The QA Inspector noted that the work was in progress and appeared to be in general conformance with the contract documents.

3. 8W PP64 W4 Lifting Lug Holes VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on LLH's at 8W PP64 W4. The QA Inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing utilizing a G.E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

4. 8E PP64 E4 Lifting Lug Holes VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on LLH's at 8E PP64 E4. The QA Inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing utilizing a G.E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

5. 9E PP77 E3 Lifting Lug Holes #1 & 3

The QA Inspector made periodic observations of ABF welder Jorge Lopez performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on LLH's #1 and 3 located at 9E PP77 E3. The QA Inspector observed the QC Inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

6. 9W PP76 W4 #1

The QA Inspector randomly observed ABF welder Fred Kaddu performing SMAW in the 1G flat position on LLH #1 located at 9W PP76 W4. The QA Inspector observed the QC Inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050-CU. The work is in progress and the QA Inspector noted that the work appeared to be in

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

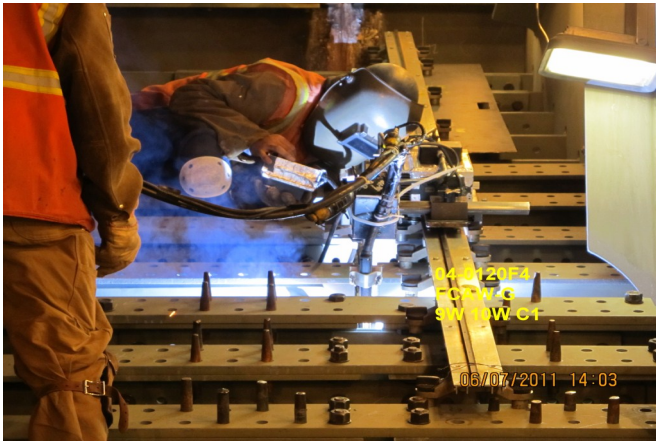
general conformance with the contract documents.

7. 2W PP18 A1 Storm Ties (Temporary Catwalk)

The QA Inspector randomly observed ABF welder Rick Clayborn performing SMAW in the 1G Flat position on the Storm Ties for the temporary “Catwalk” located at 2W PP18 A1, 2W 3W PP19 A1, 2W 3W PP19 A5, 2W PP18 A5, (2) at 5W PP29 A1 and (2) at 5W PP30 A1. The QA Inspector observed the QC Inspector Jesse Cayabyab as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-F2200-2. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

Summary of Conversations:

At the beginning the shift the QA Inspector met with QC Inspector John Pagliero and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
